

# Work Order ID 72752

Friday, August 12, 2011 9:02:12 AM



Page 1

Item ID: D4006-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Channel

Start Date: 8/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date: 11-08-12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-8-15

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72752

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Start Date: 8/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

*5 ulos 115*



QC

Memo

0.00

Quality Control

*(18)*

130

Bend as per dwg

0.00

*58 116913*



Brake NC

Memo

0.00

Brake NC

C'sink as per dwg

*EP 11/08/23 (18)*

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*18 x 1/2 m 11/09/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72752**

Friday, August 12, 2011 9:02:12 AM



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Item ID: D4006-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Channel

Start Date: 8/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

Sulorlop

(418)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST 107

0.00



Packaging

Memo

0.00

Packaging

(187)

SP 11-09-06

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/06

MF 11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 12, 2011 9:02:19 AM

Page 1

Work Order ID: 72752



Parent Item: D4006-3



Parent Item Name: Channel

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 09.12.22 new Issue Prelim EC verified by:DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

216.3800

0.0971

1.022105

2



B11-8-15

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

216.38

117018

7.88

117392

208.5

11792

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	72752
<b>Description: Channel</b>		<b>Part Number:</b>	D4006-3
<b>Inspection Dwg: D4006      Rev: A</b>		<b>Page 1 of 1</b>	

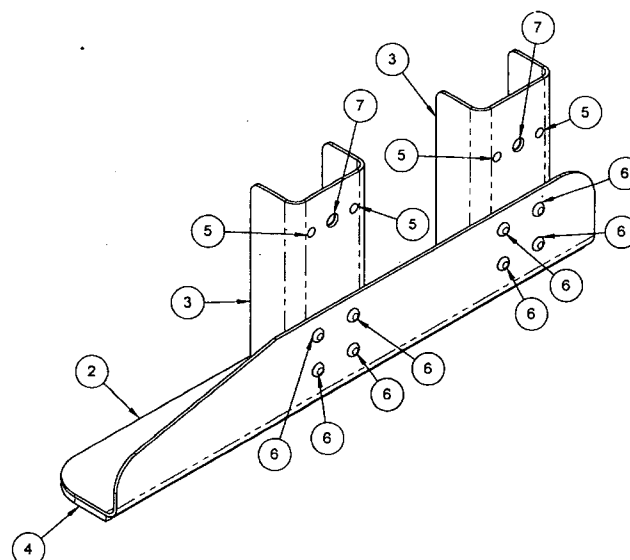
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	✓		V B02	
Ø0.129	+0.005/-0.001	.130	✓		V	
Ø0.257	+0.006/-0.001	.258	✓		V	
3.58	+/-0.030	3.587	✓		V	
1.000	+/-0.010	1.000	✓		V	
0.500	+/-0.010	.501	✓		V	
3.90	+/-0.030	3.904	✓		V	
0.827	+/-0.010	.830	✓		V	
1.38	+/-0.030	1.383	✓		V	
0.35	+/-0.030	.355	✓		V	
0.709	+/-0.010	.708	✓		V	
0.063	+/-0.010	.063	✓		V	

<b>Measured by:</b>	B	<b>Audited by:</b>	S	<b>Preliminary Approval:</b>	
<b>Date:</b>	11-8-18	<b>Date:</b>	11/8/18	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	11.01.17	New Issue	KJ	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



**D4006-041 TANK TOP SUPPORT ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3  
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

SUPPLIED  
 RETURNED  
 ENGINEERING  
**UNCONTROLLED**  
 SUBJECT TO A CHANGE  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 72752

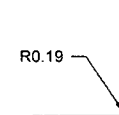
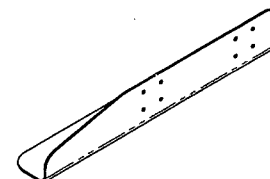
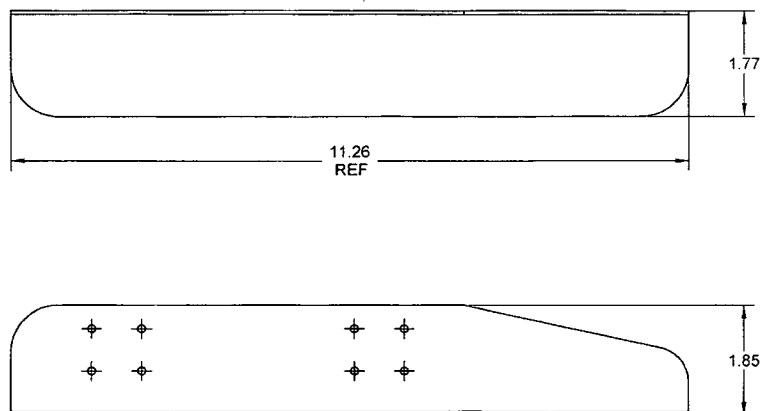
*11-08-12*

**RELEASED**  
 2010-05-05  
*M*

REV.	NEW ISSUE	BY	DATE
DESIGN			10.02.05
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4006</b>	REV. A SHEET 1 OF 6
TITLE <b>UPPER RESTRAINT</b>	SCALE NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01

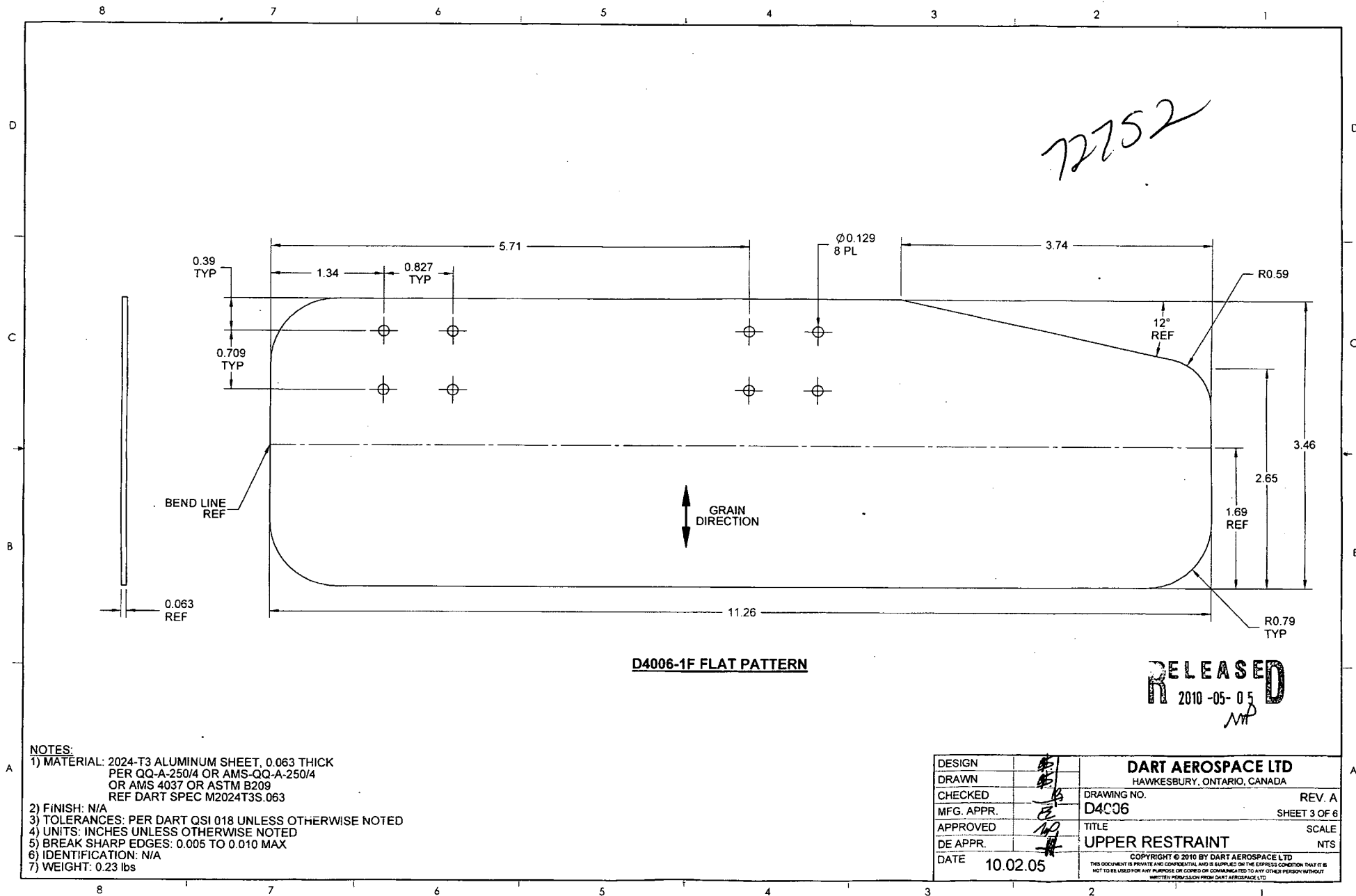


**D4006-1 ANGLE**

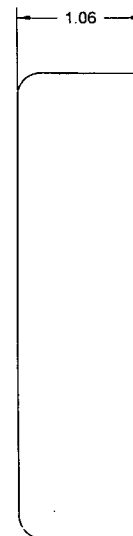
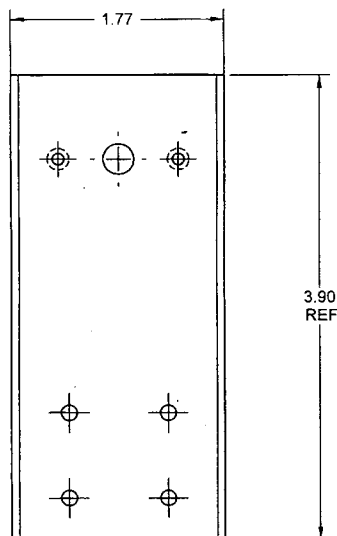
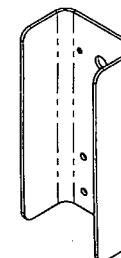
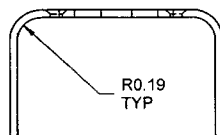
**RELEASED**  
2010-05-05  
MP

- NOTES:**
- 1) MATERIAL: MADE FROM D4006-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.23 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MR J. APPR.		<b>D4006</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>UPPER RESTRAINT</b>	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-3	REF JCA-M47-2-01



72752

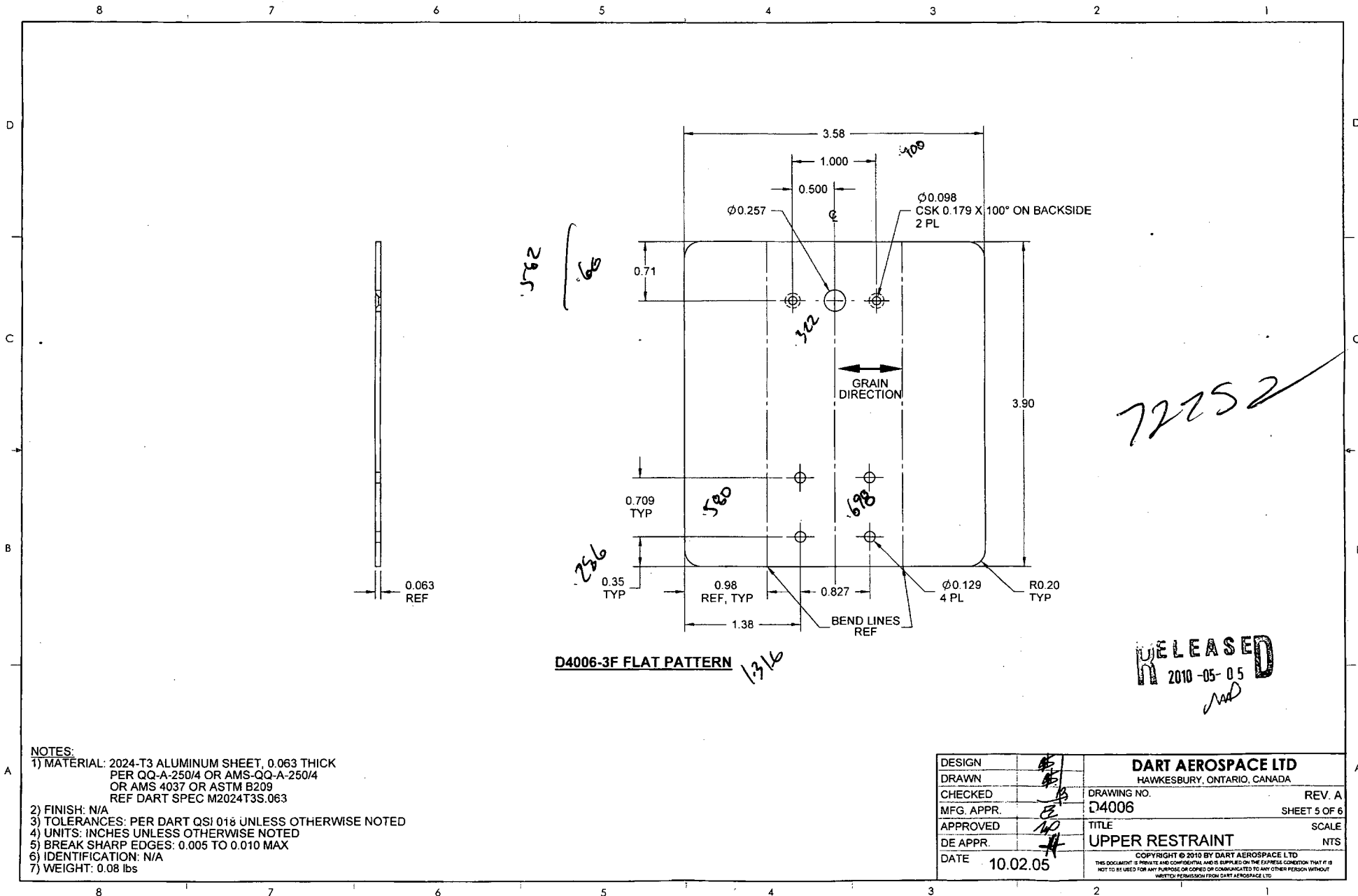
# D4006-3 CHANNEL

RELEASED  
2010-05-05  
MWP

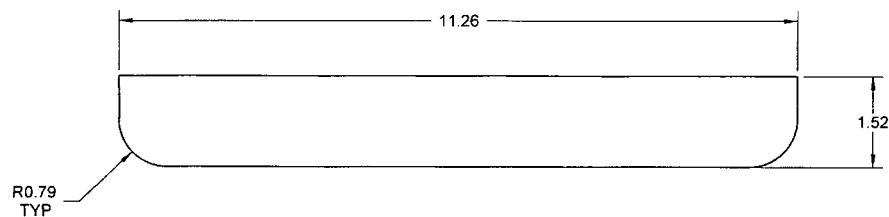
## NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 4 OF 6
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



**D4006-5 FOAM**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK  
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1  
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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